

XL-90HV Clear Gloss PRODUCT DATA



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DESCRIPTION:

- High performance epoxy hybrid coating
- Superior weathering and chemical resistance
- Cures at ambient temperature
- Low VOC – less than 100 grams per liter
- Field application
- Brush, Roll or Spray application
- XL 30a, 30 % sheen @ 60 degrees F.
- Lead and chromate free

APPLICATION USES:

- Aviation
- Commercial transport
- Concrete & Masonry
- Offshore/marine areas
- Rail & tank car construction
- Pipelines
- Industrial plants – chemical, petrochemical, waste water
- Structural Steel, Tanks

TECHNICAL DATA:

% SOLIDS by volume	75% as packaged, 71% as applied
COATINGS VOC (as packaged)	Max. 3 g/l (less water & exempt compounds)
SPRAYABLE VOC (as applied)	Max. 96 g/l (less water & exempt compounds) includes cure volatiles
COMPONENTS	XL Part A (resin) 4 parts XLB Activator (Part B = 1 part) Total of 5 parts
POT LIFE	2 hours @70° F, 21° C
SHELF LIFE	One year (unopened)
REDUCERS	Not required
FLASH POINT	109 ° F, 42.8 ° C
MIX RATIO	4:1 (4 parts resin, 1 part activator, 5 parts total)
RECOMMENDED DRY FIL THICKNESS	2 mils per coat (50 microns), 1 to 2 coats
COVERAGE	401 – 200 sq ft at recommended DFT (no loss)

SURFACE PREPARATION:

The XL coating may be applied over appropriately prepared steel, aluminum, galvanizing, concrete, masonry, and coated surfaces. The XL coating may also be applied over appropriately primed substrates.

Steel—Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6 or 7. Substrate must be clean and dry prior to application of the XL coating. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

Aluminum & Galvanizing— Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6 or 7. Substrate must be clean and dry prior to application of the XL coating. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

Concrete & Masonry—Surface must be cured, clean, dry and free of contamination and disintegrated or chalky materials. SSPC-SP13 may be used for surface preparation of concrete and masonry block. Substrate preparation must be clean and dry prior to application of the XL coating. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

Coated Surfaces—Physically abrade existing coated surfaces thoroughly and completely with 220 grit or equivalent abrasive paper or scuff pad. Substrate must be clean and dry prior to application of the XL coating. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

INSTRUCTIONS—MIX RATIO:

Stir Part A resin **thoroughly** and shake Part B Activator then add Part B Activator to Part A resin and thoroughly mix to ensure uniform mixture. Measure 4 parts of XL A resin after stirring and add 1 part XL B Activator after shaking for a total of 5 parts. Additional reduction is not necessary.

APPLICATION: Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max. at the air cap for HVLP spray guns. Apply 1-2 medium wet coats until desired coverage and flow is reached. Allow a 5 to 10 minute flash time between coats. Recommended film thickness is 2.0 to 4.0 mils DFT. Surface temperatures must be at least 5° F (3° C) above the dew point for application. Relative humidity below 40% will extend the dry times

SPRAY GUN SET-UP & PRESSURE:

TYPE	FLUID TIP	SPRAYING PRESSURE
Siphon Feed	1.4 mm – 1.7 mm	40-65 PSI
Gravity Feed	1.3 mm – 1.4 mm	40-65 PSI
HVLP Siphon	1.3 mm- 1.5 mm	Max. 10 PSI @ the air cap
HVLP Gravity	1.3 mm – 1.5 mm	Max. 10 PSI @ the air cap
Brush—natural bristle		
Roller—¼ to ¾ inch nap, phenolic core non shed		

DRY TIMES: Dry times @ 70° F (21° C) and 50% RH

Tack Free	4 hours
Dry Time	24 hours
Recoat	May be recoated with itself at any stage.

CLEAN UP:

Follow local, state and federal regulations. Acetone may be used to clean application equipment immediately after use.

Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on experience and research and is believed to be reliable. As the manufacturer has not control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.
